

Work Order ID 133255

Thursday, May 28, 2015 1:22:01 PM

1.33255

Page 1

Item ID: D5190-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Weld Pin
Start Date: 5/28/2015 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 5/28/2015 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: MAY 28 2015 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5190	A

100 Hardinge CNC LATHE SMALL 0.00
100
Hardinge Memo 0.00
Hardinge CNC Lathe Small 1- Turn D5190-3 as per Folio FB V/A & Dwg D5190
Folio Rev: V/A Dwg Rev: A
2-Deburr

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
QC Memo 0.00
Quality Control

120 QC8- Inspect parts - second check 0.00
120
QC Memo 0.00
Quality Control

DAS
44
9-89 15/05/28

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Item ID: D5190-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Weld Pin

Start Date: 5/28/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/28/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>W/A002</i>	0.00							
150									
Packaging	Memo	0.00							
Packaging	LOCATION: WA002								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MS.6-1

Picklist Print

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Work Order ID: 133255

133255

Parent Item: D5190-3

D5190-3

Parent Item Name: Weld Pin

Start Date: 5/28/2015

Required Date: 5/28/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.11.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M4130NR0.375

Purchased

No

f

15.7705

1

M4130NR0 375

4130 steel RD bar .375"

Location

Loc Qty

Loc Code

MAT032

15.7705

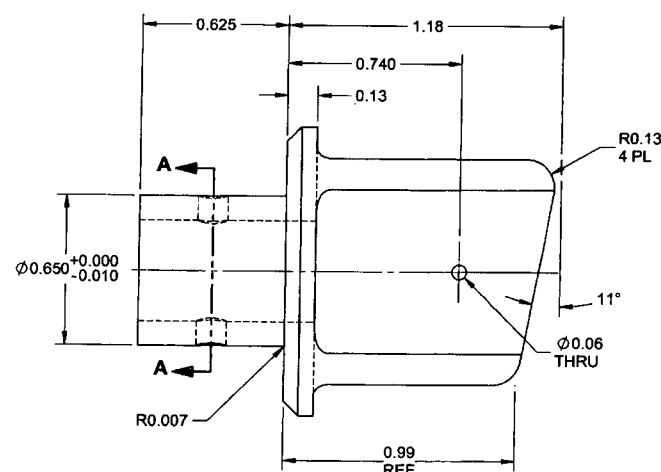
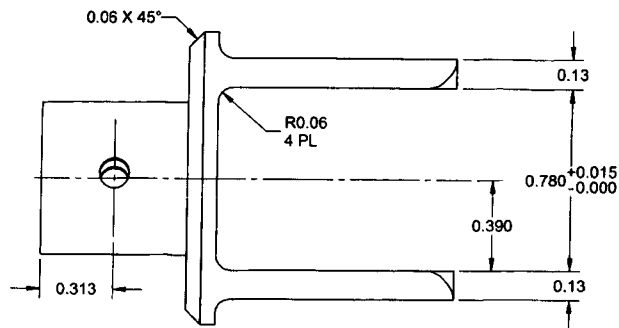
123724

3.7705

m132387

12

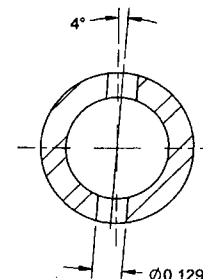
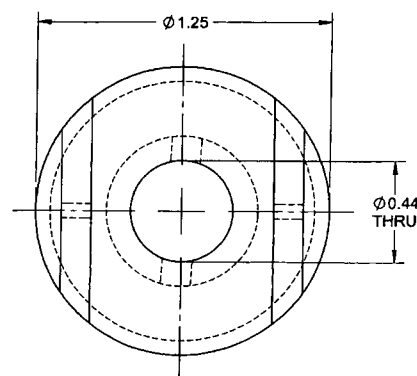
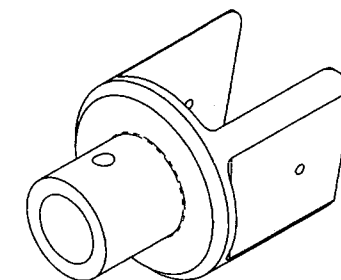
1 J.C.L. 15/05/28



D5190-1 ARMREST FITTING

- NOTES:
- 1) MATERIAL: AISI 4130N ROUND BAR
PER MIL-S-6758 OR AMS 6348/6370/6528
REF M4130N-R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.13 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO ADDENDUM
WITHOUT NOTICE
WORK ORDER
NO. 133255 MJS
15 05-28



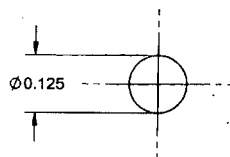
SECTION A-A

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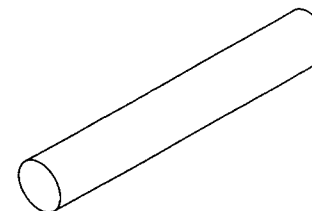
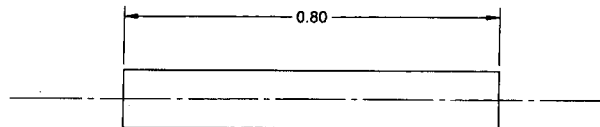
2015 FEB 04
ZEN 15-522 90

APPROVED

A		NEW ISSUE		AJS	14.11.19
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	AJS			SHEET 1 OF 2	
CHECKED	AP	DRAWING NO. D5190		SCALE	
MFG. APPR.	JLM	TITLE ARMREST MACHINED PARTS		NTS	
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DE APPR.	DS				
DATE	14.11.19				



D5190-3 WELD PIN



NOTES:

- 1) MATERIAL: AISI 4130N ROUND BAR
PER MIL-S-6758 OR AMS 6348/6370/6528
REF M4130N-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: <0.01 lbs

RELEASED

2015 FEB 04
EN 15-522 92

APPROVED

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5190	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ARMREST MACHINED PARTS	NTS
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